

Work Order ID 156423

Friday, January 27, 2017 2:00:30 PM

156423

Page 1

Item ID: D4635-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Ceiling Panel Assembly, LH
Start Date: 1/16/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/27/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: FEB 02 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4635	F								DAS 07 9-89
100		0.00							
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								17/03/21
110		0.00							DAS 07 9-89
110									
Small Fab	Memo	0.15							
Small Fab	1- Assemble as per Dwg D4635-041								17/03/21
	2-Install speakers								
	3- Install Air valves								
	4-Install Wiring Harness								
	5-Install wiring harness								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

Page 2

Friday, January 27, 2017 2:00:30 PM

Quality Control

DAS
38
9-89

DAS
6
9-88

JUN 07 2017

JUN 07 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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OTHER :									

Picklist Print

Friday, January 27, 2017 2:00:33 PM

Page 1

Work Order ID: 156423

156423

Parent Item: D4635-041

D4635-041

Parent Item Name: Fwd Ceiling Panel Assembly, LH

Start Date: 1/16/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Doc Release DL
Update 13/07/09 DL ver: DD
13/12/09 DL
Ipp Rev. E Dwg Update 14/01/09 DL
Dwg. Update 15/01/27 DL

IPP Rev B
IPP Rev. C Dwg.
IPP Rev D Dwg Update
IPP Rev. F

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4652-5		Manufactured	No			100	Each	0.0000	2	2			DAS 07 9-89 17/03/21
D4652-5				122691					**				
Air Valve, 1.25 Id Disk Type													
MS24693-BB51		Purchased	No			100	Each	373.0000	8	8			DAS 07 9-89 17/03/21
MS24693-BB51									**				
Screw													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST288		373							
				m128057		373							
D4635-141		Manufactured	No			100	Each	0.0000	1	1			DAS 07 9-89 17/03/21
D4635-141				156377					**				
Fwd Ceiling Replacement Panel Assembly, LH													
D4646-1		Manufactured	No			100	Each	22.0000	2	2			DAS 07 9-89 17/03/21
D4646-1									**				
Plenum Cap Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF009		22							
				154711		22							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER :					

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Page 2

Work Order ID: 156423

156423

Parent Item: D4635-041

D4635-041

Parent Item Name: Fwd Ceiling Panel Assembly, LH

Start Date: 1/16/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4655-1 Manufactured No

100 Each 23.0000 2 2

D4655-1

Speaker

★★

DAS
07
9-89

17/03/21

Location

Loc Qty

Loc Code

MF002

23

117634

5

154865

18

D4708-9 Manufactured No

100 Each 17.0000 2 2

D4708-9

Lanyard

★★

DAS
07
9-89

17/03/21

Location

Loc Qty

Loc Code

MF004

17

150077

2

154884

15

D4728-041 Manufactured No

100 Each 13.0000 1 1

D4728-041

LH Cabin Speaker #1

★★

DAS
07
9-89

17/03/21

Location

Loc Qty

Loc Code

MF002

3

124216

3

MF009

10

124216

10

D4728-043 Manufactured No

100 Each 14.0000 1 1

D4728-043

LH Cabin Speaker #2

★★

DAS
07
9-89

17/03/21

Location

Loc Qty

Loc Code

MF002

3

124296

3

MF009

11

124296

11

Friday, January 27, 2017 2:00:33 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, January 27, 2017 2:00:34 PM

Work Order ID: 156423

156423

Parent Item: D4635-041

D4635-041

Parent Item Name: Fwd Ceiling Panel Assembly, LH

Start Date: 1/16/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4728-059

Manufactured No

100

Each

14.0000

1

1

D4728-059

Cabin Lights Harness

DAS
07
9-89

17/03/21

Location

Loc Qty

Loc Code

MF002

4

124187

4

MF009

10

124187

10

D4743-1

Manufactured No

100

Each

12.0000

2

2

D4743-1

Speaker Grill

DAS
07
9-89

17/03/21

Location

Loc Qty

Loc Code

MF005

12

149065

4

154770

8

MS21044-N08

Purchased No

100

Each

170.0000

8

8

MS21044-N08

Nut

DAS
07
9-89

17/03/21

Location

Loc Qty

Loc Code

ST302

170

m131452

12

m136502

58

m136537

100

MS21919-WDG8

Purchased No

100

Each

45.0000

6

6

MS21919-WDG8

Clamp

DAS
07
9-89

17/03/21

Location

Loc Qty

Loc Code

over008

36

m136537

36

ST293

9

m136502

9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Friday, January 27, 2017 2:00:34 PM

Page 4

Work Order ID: 156423

156423

Parent Item: D4635-041

D4635-041

Parent Item Name: Fwd Ceiling Panel Assembly, LH

Start Date: 1/16/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

100

Each

1,548.000

8

8

NAS1149DN832.J

Washer

DAS
07
9-89

17/03/21

Location

Loc Qty

Loc Code

ST264

1548

M135297

1548

8
7

PLT1.5M-M

Purchased

No

100

Each

2,675.000

7

PI T1 5M-M

Tie Wrap

DAS
07
9-89

17/03/21

Location

Loc Qty

Loc Code

ST585

2675

m129712

2675

5
7

Friday, January 27, 2017 2:00:34 PM

Shop Packet Print

Page 4

DQA: _____ Date: _____

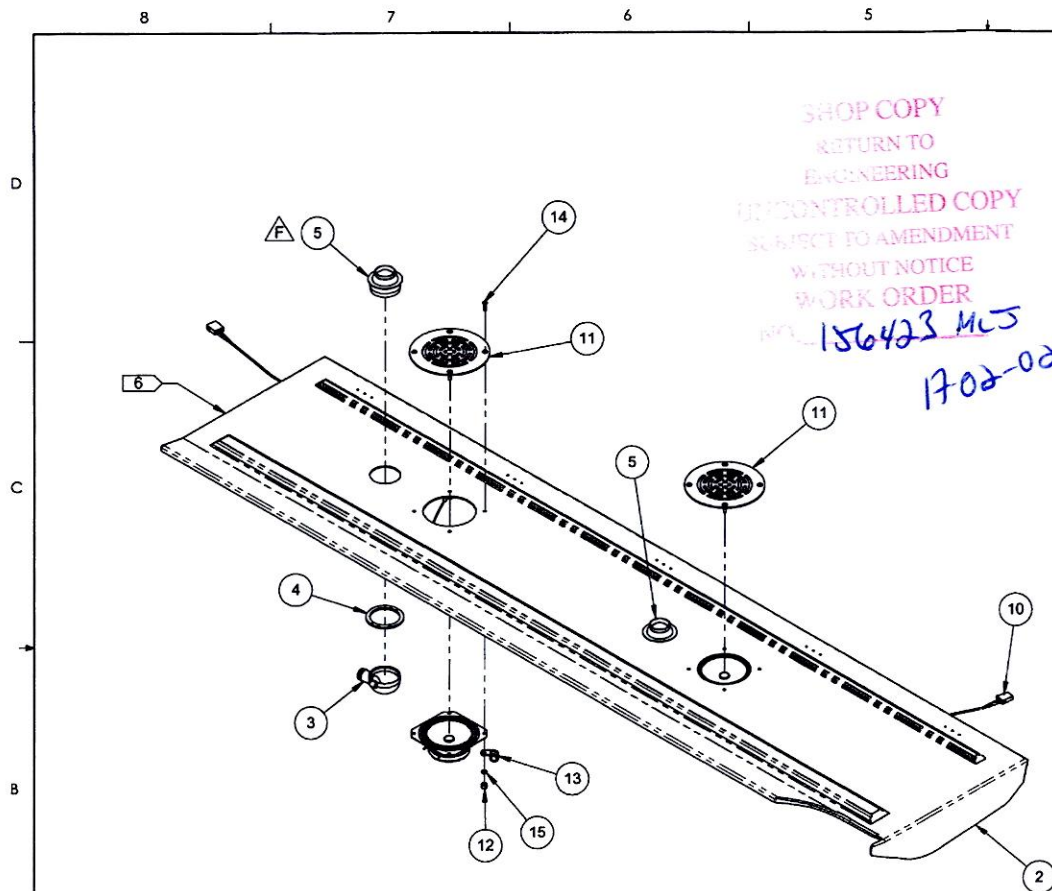


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



D4635-041 LH, FWD CEILING PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 8.0 lbs
- 8) INSTALL D4728-041/-043/-059 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

ITEM NO.	QTY. -041	P/N	DESCRIPTION
1	X	D4635-041	LH, FWD CEILING PANEL ASSY
2	1	D4635-141	LH, FWD CEILING REPLACEMENT PANEL ASSY
3	2	D4646-1	PLENUM CAP ASSEMBLY
4	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-5)
5	2	D4652-5	AIR VALVE, 1.16 ID DISK TYPE
6	2	D4655-1	SPEAKER
7	2	D4708-9	LANYARD
8	1	D4728-041	LH SPEAKER #1 HARNESS ASSY
9	1	D4728-043	LH SPEAKER #2 HARNESS ASSY
10	1	D4728-059	CABIN LIGHT HARNESS
11	2	D4743-1	SPEAKER GRILL
12	8	MS21044-N08	NUT, SELF-LOCKING
13	6	MS21919WDG8	CLAMP
14	8	MS24693-BB51	SCREW, CSK 100°
15	8	NAS1149DN832J	WASHER
16	7	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

RELEASED

2015 JAN 26

ECN 14-634 4

F	D4652-5 WAS D4652-1 (ZN D4-1, D4-3, D4-5, D4-7)	RF	14.11.28
E	REVISE BOM (ZN D4-1, D4-3, D4-5, D4-7); ADDED NOTE 11) (ZN A8-9, A8-10, A8-11 & A8-12); REVERSE VIEW -142/-144 (ZN B6-10, B6-12); RANGE 1.5-1.8 WAS 1.8 (ZN A7-17); DIMENSION HAS SHIFTED DUE MATERIAL THICKNESS	RF	14.01.09
D	CORRECTING VIEW FOR ITEM 8 (ZN B2-2); ADDED D5022-1 (ZN D4-9, C3-9, D4-10, C2-10), D5022-3 (ZN D4-11, C6-11), D5022-5 (ZN D4-12, B6-12); DIMENSION SHIFTED DUE ADDING D5022-1/-3/-5; REVISE NOTE 10) (ZN A8-9, A8-10, A8-11, A8-12); NOTE 1) (ZN A8-13, A8-14, A8-14, A8-15, A8-16)	RF	13.12.09
C	REVISE NOTE 8) (ZN A8-9, A8-10, A8-11 & A8-12); 32 WAS 34 (ZN C5-15, B5-16); CORRECT TYPO #1 WAS #3 (ZN D4-3); CHANGE TOLERANCE (ZN C3-13, B2-14, B5-17, B7-17, D2-17, D4-17, A3-18)	RF	13.06.18
B	ADDED D4635-141/-142/-143/-144 (ZN B4-9, B4-10, B4-11, B4-12); REVISE D4635-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADDED D4732-41 (ZN B5-8); CHANGE TO D4743-1 SPEAKER GRILL AND MS24693-BB51 SCREWS (SHT 1, 3, 5, 7); ADD VIEWS R-R' (ZN A7-17) AND S-S' (ZN A5-17); UPDATE DETAIL 'D' (ZN C7-18)	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
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